

Thursday, 28/08/2008 1:16:39 PM  
User: Melanie Fauteux

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ANGLE  
 Job Number : 41656  
 Estimate Number : 13281  
 P.O. Number :  
 This Issue : 28/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : SMALL / MED FAB  
 Previous Run : 41022  
 Written By :  
 Checked & Approved By : MF 08-08-28  
 Comment : Est Rev:A 08-04-25 new issue DD verified by:EC  
 Est Rev:B 08-07-14 revB as per dwg DD verified by:ec

Part Number : D36981  
 Drawing Number : D3698 REVB  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 04/09/2008 Qty: 8 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.4700 sf(s)/Unit Total : 3.7598 sf(s)  
 6061T6 aluminium sheet .032" thick  
 (M6061T6S032)  
 Batch: B315 B 8-8-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3698  
 Dwg Rev: B B 8-8-29  
 Prog Rev: B  
 \*\*\*\*grain direction along 1.378" \*\*\*\*  
 2- Deburr if necessary B 8-8-29

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Bend 105 deg. angle as per Dwg D3698

808/09/02





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 41656

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form curve as per dwg D3698 and verify using template DT9001

FF 08/09/24

(7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/24 (x7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/09/26

(7x)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

N/A

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-26

(x7)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 118

8/09/08

(7x)

54

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

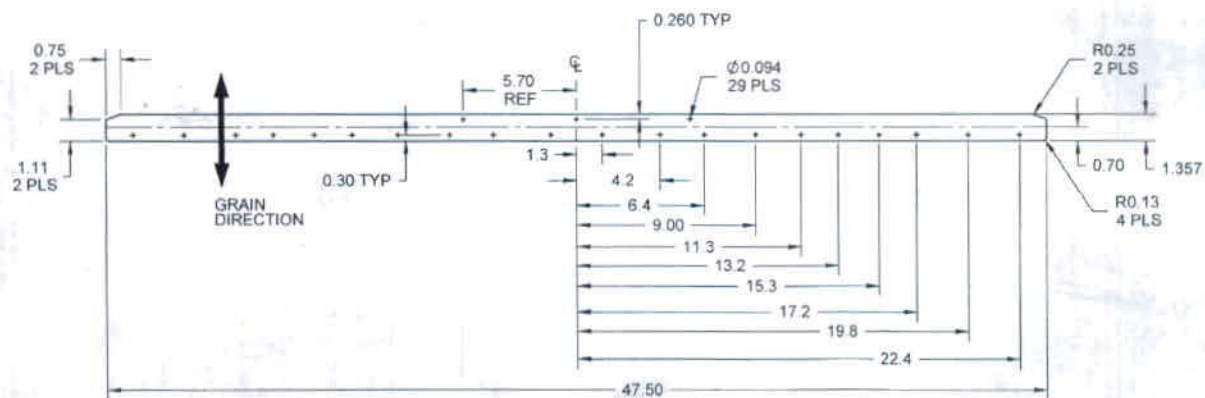
08/09/30

Job Completion



MF 08-09-26





**SECTION A-A**

RECORDED

**D3698-1F FLAT PATTERN**

1) MATERIAL: 6061-T6 (Q-A-250/11) SHEET 0.032 THICK (REF. DART SPEC. M6061T6S 032)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 0.20 lbs  
8) FORM AS PER TEMPLATE DT9001

B	REMOVE POWDER COAT. ZONE A & B	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.		DESCRIPTION	BY DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3698</b>  TITLE <b>COPPERT ANGLE</b>	REV. P
DRAWN	RF		SHEET 1 OF 1
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE DISCLOSED AND NOT REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	





DART AEROSPACE LTD		Work Order: 41656
Description: SUPPORT ANGLE		Part Number: D 3698-1
Inspection Dwg: D3698-1 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .094	+0.004 -0.001	.097	x			
47.50	±.030	47.50	x			
1.357	±.010	1.358	x			
.30	±.030	.309	x			
.260	±.010	.260	x			
1.11	±.030	1.10	x			
.75	±.030	.758	x			
5.70	±.030	5.695	x			
1.3	±.100	1.30	x			
4.2	±.100	4.200	x			
6.4	±.100	6.404	x			
9.00	±.030	9.00	x			
11.3	±.100	11.3	x			
13.2	±.100	13.2	x			
15.3	±.100	15.3	x			
17.2	±.100	17.2	x			
19.8	±.100	19.8	x			
22.4	±.100	22.4	x			

Measured by: B	Audited by: S	Prototype Approval: A
Date: 8-8-21	Date: 08/08/21	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

